

Work Order ID 54638-2 ² SPLIT

December 15, 2009 9:59:13 AM



X5 SCRAP

Page 1

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Seat Back, LH/RH

Start Date: 15/12/2009 Start Qty: 20.00

Required Date: 18/12/2009 Req'd Qty: 20.00

Cust Item #:

Customer:

Reference:

Approvals: Process Plan: *RR*

Date: *04/12/11* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3774

Rev B

100



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Set up machine program D3774-3 Set up clamping frame as per folio

SCRAP

Ph

10/01/11

110



HAND FINISHING THERMOFORMING

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

10/01/11

10/01/12 *X8*
10/01/12 *X3*

120



THERMOFORMING MACHINE

0.00

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D32811 and Folio FTA 011 Dwg. Rev.


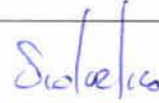
B Folio Rev. *B*

10/01/12

10/01/12 *X8*
10/01/13 *X3*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3774-3 PAR #: _____ Fault Category: Thermoforming NCR: Yes No DQA: 1 Date: 10/02/12
 Resolution: SCVAP Disposition: Scrap QA: N/C Closed: 10/03/31 Date: 10/03/31

NCR: 54638-2		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/1/12	#120	During inspection /trimming it was Found that the parts were cracking in the corners R.C. Parts were formed by being on the molds causing a Build up of stress "Process"		-Scrap + Destroy Qty x5 - change FB T.H. Forming Process and attach a copy of new process for Ref.	SH 10-01-12			S 10/01/12
			MP QSI 04/2	-Annual Remanent parts that were not cracked @ 285 °F. parts cracked		S 10/02/12	MP QSI 04/2	S 10/01/12
				Qty x6 at all Bales During testing Solata				

NOTE: Date & initial all entries

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Page 2

Item ID: D3774-3

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Start Date: 15/12/2009 Start Qty: 20.00



Cust Item ID:

Required Date: 18/12/2009 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

BB
10/01/14

140

HAND FINISHING THERMOFORMING

0.00



Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

BB
10/01/14

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

1) Check dimensions to ensure conformity to drawing tolerances.

BB
10/01/14

PTO →

Work Order ID 54638

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Page 3

Item ID: D3774-3

Accept



Setup Start



Revision ID:

Item Name: Seat Back, LH/RH

Stop



Start Date: 15/12/2009 Start Qty: 20.00

Required Date: 18/12/2009 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W 003-31

Picklist Print

December 15, 2009 9:59:18 AM

Page 1

Work Order ID: 54638

Parent Item: D3774-3

Parent Item Name: Seat Back, LH/RH


Comments:

Start Date: 15/12/2009

Required Date: 18/12/2009

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	2,011.175	213.3400			
												
GE PLASTICS LEXAN SHEET												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

2011.175198

103106

1.6765

105330

47.8767

109455

40.5717

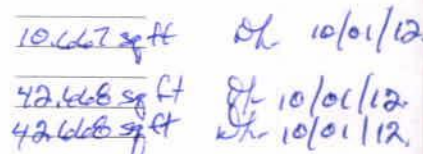
111710

329.893632

112585

1591.15667





DART AEROSPACE LTD		Work Order:	54138
Description: Seat Back		Part Number:	D3774-3
Inspection Dwg: D3774 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: _____ **Date:** _____

TRIMMING SECTION

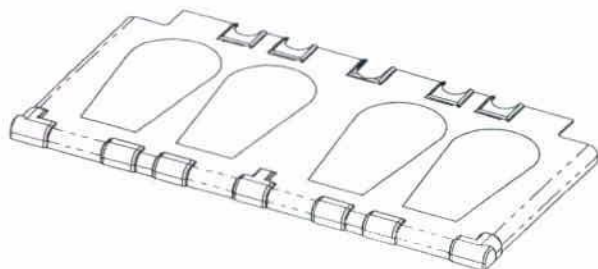
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3	+/-0.100					
33.9	+/-0.100					
0.085	Min					
0.100	Min					
0.100	Min					
0.100	Min					
0.100	Min					
0.100	Min					
0.100	Min					
0.100	Min					
0.100	Min					

Measured by: _____ **Date:** _____

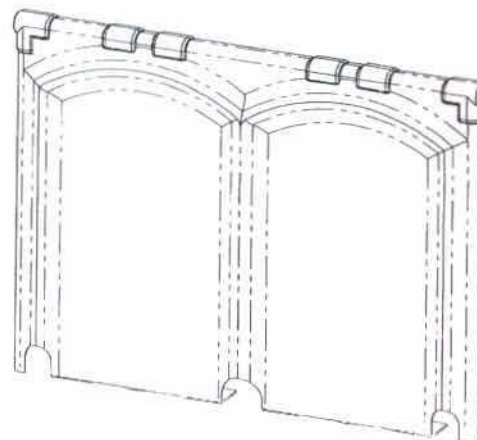
Audited by: _____ **Date:** _____

Prototype Approval: _____ **Date:** _____

Rev	Date	Change	Revised by	Approved
A	08.09.04	New Issue	KJ/DL	
B	09.05.19	Dimension 17.4 removed	KJ	



D3774-1 SEAT BOTTOM

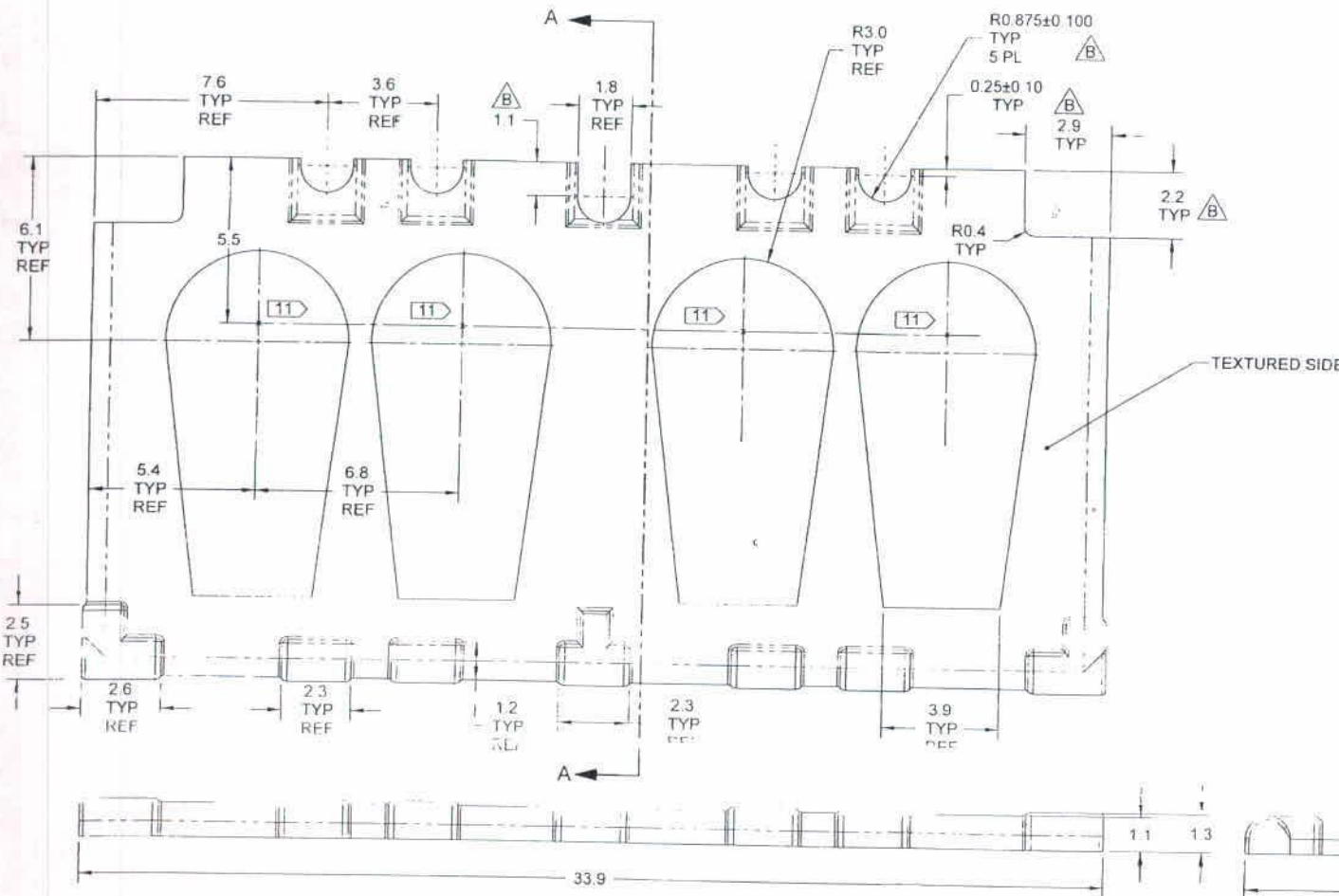


D3774-3 SEAT BACK

RELEASED
06-08-11/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54638
12/04/15

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES	PH	08.07.25
A	NEW ISSUE	HS	08.08.23
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	PH	DRAWING NO.	REV. B
MFG APPR.	PH	D3774	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	SEAT	NTS
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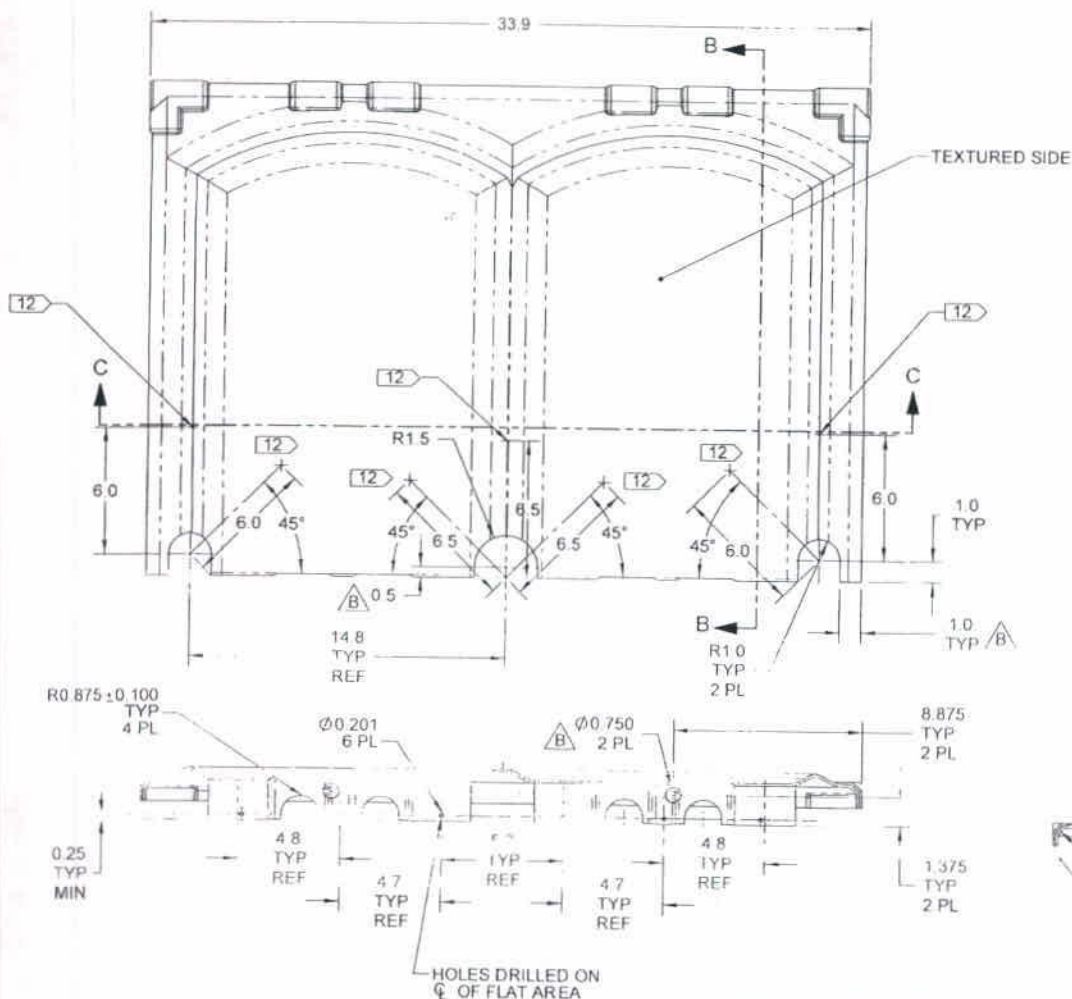
D3774-1 SEAT BOTTOM

SECTION A-A

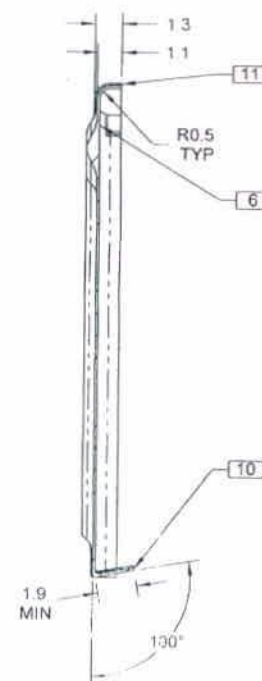
RELEASED
08-06-11

NOTES:
MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS 125-F60029-04)
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
WEIGHT: 2.93 lbs
PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

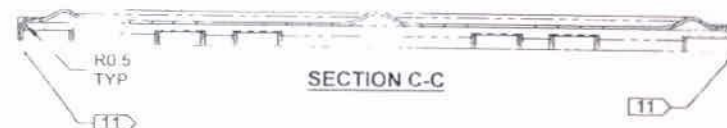
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DRAWN	HS		
CHECKED	HS	DRAWING NO.	REV. B
MFG. APPR.	HS	D3774	SHEET 2 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	SEAT	NTS
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D3774-3 SEAT BACK



SECTION B-B



SECTION C-C

RELEASED
08-05-11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MA		
CHECKED		DRAWING NO.	REV. B
MFG APPR		D3774	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR		SEAT	NTS
DATE	08.07.25	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

NOTES:
MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS. 125-F60029-04)
FINISH: NONE
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
WEIGHT: 4.82 lbs
PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100